

Work Order ID 51803

Thursday, September 03, 2009 11:43:20 AM

Page 1

Item ID: D350-636-011

Accept

Revision ID: F

Item Name: Skidtube LH

Setup Start

Stop

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 09-9-03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

0.00

100



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

S 09/10/09

HJ for BG 09/10/06

51803

Work Order ID 51803

Thursday, September 03, 2009 11:43:20 AM

Page 2

Item ID: D350-636-011

Accept

Revision ID: F

Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R□□□ Aluminum Rod

mill 682

10-Grind welds flush as per Dwg D2750

BE 09/09/15

ANM 9-9-15

BE 09/09/15

ANM 9-9-15

Work Order ID 51803

Thursday, September 03, 2009 11:43:20 AM

Page 3

Item ID: D350-636-011

Accept

Revision ID: F

Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

12- Scribe batch# inside per dwg D2750

AWM 9-9-15

120

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

④ /

④ /

MA 09 16 ①

Work Order ID 51803

Thursday, September 03, 2009 11:43:20 AM

Page 4

Item ID: D350-636-011

Accept

Revision ID: F

Item Name: Skidtube LH

Setup Start

Stop

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

A.N. 09-09-16 @

Work Order ID 51803

Thursday, September 03, 2009 11:43:20 AM

Page 5

Item ID: D350-636-011

Accept

Revision ID: F

Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291

batch: 1112391 ☐☐☐

exp. date: 03/20/2010

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R ☐☐☐ Aluminum Rod batch: 1109213

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

BE 09/09/17

DP 9-9-26

PD 09.09.28

AWM 9-9-30

Work Order ID 51803

Thursday, September 03, 2009 11:43:20 AM



Page 6

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

11-Deburr holes

AWM 9-9-30

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

2) 8 09/09/30



✓

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) 8 09/09/30



✓

190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

2) 2 09/10/01



✓

Work Order ID 51803

Thursday, September 03, 2009 11:43:20 AM

Page 7

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



1112260

0.00

09/10/01

0

0

Powdercoat

Memo

Powder Coating

START TIME: 9:15AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 9:45AM

210

QC3- Inspect Part Finish

0.00



bl

0.00

09/08-5

0

QC

Memo

Quality Control

Inspect for foreign object per QSI 024

220

HandFinishing

0.00



MD 09/10/05

0.00

21

HandFinish

Memo

Hand Finishing

1- Install inserts as per Dwg D2750

Work Order ID 51803

Thursday, September 03, 2009 11:43:20 AM

Page 8

Item ID: D350-636-011

Accept

Setup Start

Revision ID: F

Stop

Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: 1/AS

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: m112339

EXP DATE: 10/20

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: m101223

5-Coat all exposed fasteners with "LPS Procyon" batch: m104251

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

28 02/10/06

MO 09/10/05



last

0084

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-011 PAR #: _____ Fault Category: Prod. sk. cl tubes NCR: (Yes) No DQA: [Signature] Date: 05.10.14
 Resolution: re-work Disposition: re-work QA: N/C Closed Date: 05.10.14

NCR: <u>51803</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/10/12	Found at step 230	Found at Deepin Assembly that the holes at section AS-AS are too small. (0.375") welder used wrong drill bit	[Signature]	- Drill out x-bolt space to 0.404" (1/4 Drill) + be Deburr	PD 09.10.02	[Signature]	[Signature]	S 09/10/02
		Re wasn't seen at inspection also exposed at welding (didn't know) Also Drwg. has no inside Dim. for hole (size is stuck x-bolt size) R.C: Human error.	[Signature]	- touch up with Alodine as required	UMD 09/10/05	[Signature]	[Signature]	S 09/10/02

NOTE: Date & initial all entries

Work Order ID 51803

Thursday, September 03, 2009 11:43:20 AM

Page 9

Item ID: D350-636-011

Revision ID: F

Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

MP 09/10/07

X1

Packaging

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

802/10/07

Ⓟ

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

270

Packaging

0.00



Packaging

Memo

0.00

Package as per PPP D350-636-011

Mv-6

P 9/10/07

Work Order ID 51803

Thursday, September 03, 2009 11:43:20 AM

Page 10

Item ID: D350-636-011

Revision ID: F

Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
StopSequence ID/
Work Center ID

280



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

09/10/08

U 9.10.08

Picklist Print

Page 1

Thursday, September 03, 2009 11:43:28 AM

Work Order ID: 51803

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2744RevC		Manufactured	No			110	Each	50.0000	1.0000			
												
Cap												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	50
44892	15
47488	35

D2600-3-BENTRevD1 Manufactured No



Extrusion Bent

D2743RevB Manufactured No



Crossbolt Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG	50
50281	50

Main Warehouse

ST	244
44891	2
45555	177
48275	65

[Handwritten signatures and notes]

1 BE 09/09/15

8 50675 (1) BE 09/09/15

8 DD 09.09.28

Picklist Print

Thursday, September 03, 2009 11:43:28 AM

Work Order ID: 51803



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739RevD		Manufactured	No			160	Each	6.0000	1.0000			
350 I Beam												

B51919
DP 9-9-26

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	4	
50353	4	
Main Warehouse		
ST	2	
47124	1	
47681	1	

D3490-3RevA

Manufactured No

160

Each

112.0000

4.0000



Cross Bolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	112	
45560	22	
47471	35	
48276	55	

4 80 09.09.28

Picklist Print

Thursday, September 03, 2009 11:43:28 AM

Work Order ID: 51803



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3490-1RevA Manufactured No



Cross Bolt Spacer

160

Each

165.0000

4.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

165

45338

2

47118

4

47657

50

48277

109

4 PD 09.09.28

ALS4-1032-225 Purchased No



Insert

220

Each

8,785.000

38.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8785

107441

16

110768

8769

X30 MD 09/10/05

D3492-041RevC Manufactured No



Plug Assembly

230

Each

3.0000

8.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

43816

3

X18 MD 09/10/05

Thursday, September 03, 2009 11:43:28 AM

Shop Packet Print

Picklist Print

Page 4

Thursday, September 03, 2009 11:43:28 AM

Work Order ID: 51803



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-3RevA		Manufactured	No			230	Each	22.0000	1.0000			
Wearshoe												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 22

47720 11

50216 11

AN8C35A

Purchased

No

230

Each

167.0000

1.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 167

102180 1

106896 1

110105 65

110847 100

X1 mp 09/10/08

X1 mp 09/10/08

Picklist Print.

Thursday, September 03, 2009 11:43:28 AM

Work Order ID: 51803



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA 		Manufactured	No			230	Each	18.0000	1.0000			
Wearshoe												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 18

40551 1

47537 4

50237 13

D3488-041RevB

Manufactured No



230 Each 29.0000 1.0000



Blade Fitting Assembly, LH

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 29

41853 1

44530 8

47348 20

XT mp 09/10/05

XT mp 09/10/05

Picklist Print

Page 6

Thursday, September 03, 2009 11:43:28 AM

Work Order ID: 51803



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-3RevA		Manufactured	No			230	Each	27.0000	1.0000			
Gasket												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	27	
46531	2	
47440	2	
47722	11	
50240	12	

AN6C44A

Purchased

No

230

Each

172.0000

4.0000



BOLT

Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG	2	
103964	2	

Main Warehouse

ST	170	
110105	4	
110155	14	
110665	1	
110865	51	
111605	50	
111649	50	

X1 mo 09/10/05

X4 mo 09/10/05

Thursday, September 03, 2009 11:43:28 AM

Shop Packet Print

Page 6

Picklist Print

Page 7

Thursday, September 03, 2009 11:43:28 AM

Work Order ID: 51803



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8 		Purchased	No			230	Each	92.0000	1.0000			
NUT												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

92

110584

5

111424

2

111637

21

112243

44

112492

20

XI

MO 09/10/05

D3536-25RevA

Manufactured

No



230

Each

21.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

21

45569

1

47011

2

47526

8

50266

10

VI

MP 09/10/05

Thursday, September 03, 2009 11:43:28 AM

Shop Packet Print

Page 7

Picklist Print

Page 8

Thursday, September 03, 2009 11:43:28 AM

Work Order ID: 51803

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3631-1RevA		Manufactured	No			230	Each	105.0000	8.0000			



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	51908	
ST	105	
38139	6	
45353	16	
47437	83	

XI MD 09/10/05

D3791-1RevA

Manufactured No

230

Each

18.0000

1.0000



Wearplate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	18	
47536	8	
50269	10	

XI MD 09/10/05

Picklist Print

Thursday, September 03, 2009 11:43:28 AM

Work Order ID: 51803



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH



Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			230	Each	2,450.000	38.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
FP	-44	
112116	-44	
Main Warehouse		
ST	2394	
112116	2394	

12612

X 38 m009110/05

Picklist Print

Thursday, September 03, 2009 11:43:28 AM

Work Order ID: 51803



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB		Manufactured	No			230	Each	272.0000	8.0000			



Bushing

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	272	
34817	2	
36230	8	
37303	1	
39587	2	
40726	2	
41114	2	
42778	19	
43754	2	
44893	37	
45556	69	
46695	18	
48278	110	

X8 mp 09/10/05

AN3C5A

Purchased

No

230

Each

646.0000

34.0000



Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	646	
111424	8	
111707	338	
112314	200	
112489	100	

X34 mp 09/10/05

Picklist Print

Thursday, September 03, 2009 11:43:28 AM

Work Order ID: 51803



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1RevC Wearpad		Manufactured	No			230	Each	46.0000	3.0000 			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 46

48288 3

50321 43

X3 mp 09/10/05

AN960C816L

Purchased

No

230

Each

330.0000

1.0000

WASHER

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 330

104093 2

107520 4

110139 29

110372 36

110584 100

111424 159

X1 mp 09/10/05

D3492-043RevC

Manufactured

No

230

Each

0.0000

8.0000

Plug Assembly

51642

x8 mp 09/10/05

Picklist Print

Thursday, September 03, 2009 11:43:28 AM

Work Order ID: 51803

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C6A 		Purchased	No			230	Each	1,048.000	4.0000			
BOLT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1048	
110372	72	
111982	976	

X4 MD 09/10/05

NAS1611-013

Purchased

No

230

Each

320.0000

1.0000

O-RING

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	320	
106513	11	
111424	109	
111758	200	

X8 MD 09/10/05

NAS1611-010

Purchased

No

230

Each

345.0000

1.0000

O-RING

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	345	
110715	50	
110915	295	



W/O: 51803		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/10/05		Replaced O-Ring NAS1611-010 By O-ring D-2594-3 Batch: <u>B51613</u> x8	MD	09/10/05	8		09/09/05 S

Part No: D350-636-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 03, 2009 11:43:28 AM

Work Order ID: 51803



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-25RevB		Manufactured	No			230	Each	11.0000	1.0000			
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

51663

XL MO 09/10/05

ST

11

47523

11

D3794-1RevA

Manufactured

No

230

Each

7.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

51668

XL MO 09/10/05

ST

7

46530

1

47212

2

47721

4

MS21043-6

Purchased

No

230

Each

1,132.000

4.0000



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1132

110584

34

111424

98

112314

1000

XL MO 09/10/05

Thursday, September 03, 2009 11:43:28 AM

Shop Packet Print

Picklist Print

Page 14

Thursday, September 03, 2009 11:43:28 AM

Work Order ID: 51803



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3493-1RevA		Manufactured	No			260	Each	115.0000	2.0000			
Washer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 115

44902 15

47710 100

2x 47710 md 09/10/07

MS21083C8

Purchased

No

260

Each

92.0000

2.0000

NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 92

110584 5

111424 2

111637 21

112243 44

112492 20

2x 112243 md 09/10/07

Thursday, September 03, 2009 11:43:28 AM

Shop Packet Print

Page 14

Picklist Print

Page 15

Thursday, September 03, 2009 11:43:28 AM

Work Order ID: 51803



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH


Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C21A  BOLT		Purchased	No			260	Each	112.0000	2.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	112	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	4	
111605	50	
111684	50	

2x 111684 mo 09/10/07

AN960C816L

Purchased

No

260

Each

330.0000

2.0000



WASHER

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

2x 111424 mo 09/10/07

Thursday, September 03, 2009 11:43:28 AM

Shop Packet Print

Page 15

Picklist Print

Page 16

Thursday, September 03, 2009 11:43:28 AM

Work Order ID: 51803



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H3L 		Purchased	No			260 230	Each	350.0000	4.0000			
WASHER												

Warehouse	Loc Qty	Loc Code
Location		
OFFSHORE		
FG	40	
102472	40	
Main Warehouse		
ST	310	
110450	2	
110806	8	
111819	300	

X4 mo 09/10/05

D2741RevC

Manufactured No

260

Each

40.0000

1.0000



Blade, 350 Skidtube

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	40	
20770	0	
45320	1	
47113	39	

X 47113 mo 09/10/07

Thursday, September 03, 2009 11:43:28 AM

Shop Packet Print

Page 16

Picklist Print

Page 17

Thursday, September 03, 2009 11:43:28 AM

Work Order ID: 51803



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH


Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3532-1RevA 		Manufactured	No			260	Each	43.0000	2.0000			
Spacer												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

43

38161

2

44904

41

2x 44904 mo 09/10/07

NAS1515H8L

Purchased

No

260

Each

129.0000

2.0000



WASHER

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

129

107581

34

108964

1

111650

94

2x 111650 mo 09/10/07

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

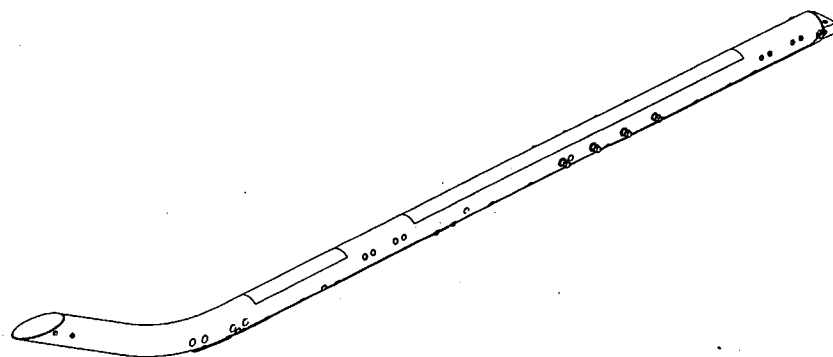
w/o 54803

RELEASED

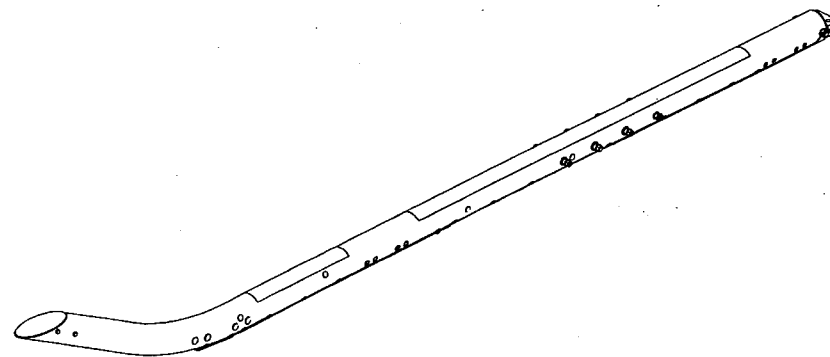
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D2750	REV. F SHEET 1 OF 11
TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

51803
4/0 ~~50803~~



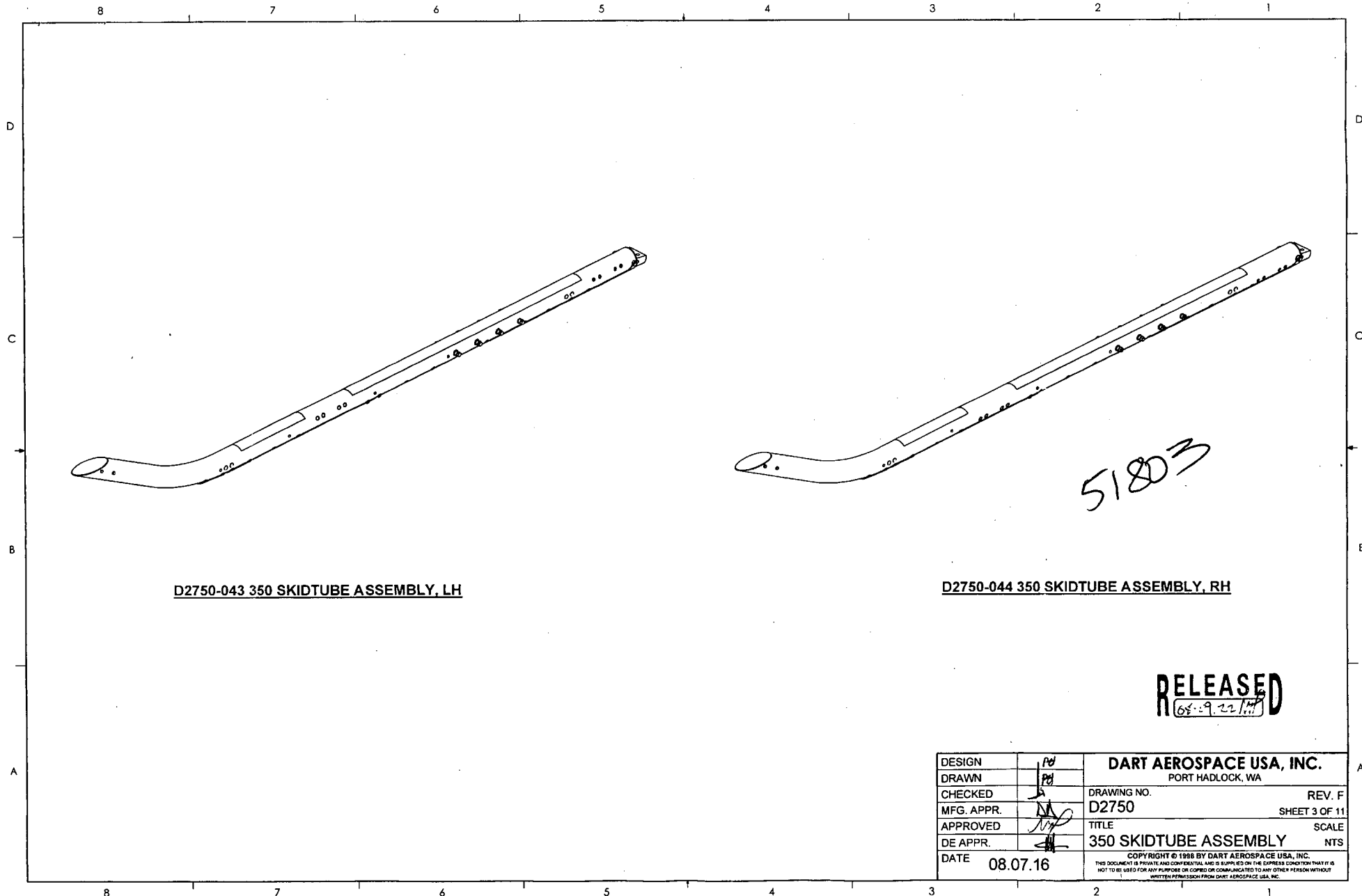
D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
08.07.16

DESIGN	PC1	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AM		
CHECKED	AM	DRAWING NO. D2750	REV. F
MFG. APPR.	AM	SHEET 2 OF 11	
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



51803

RELEASED
68-9-22

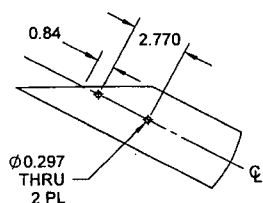
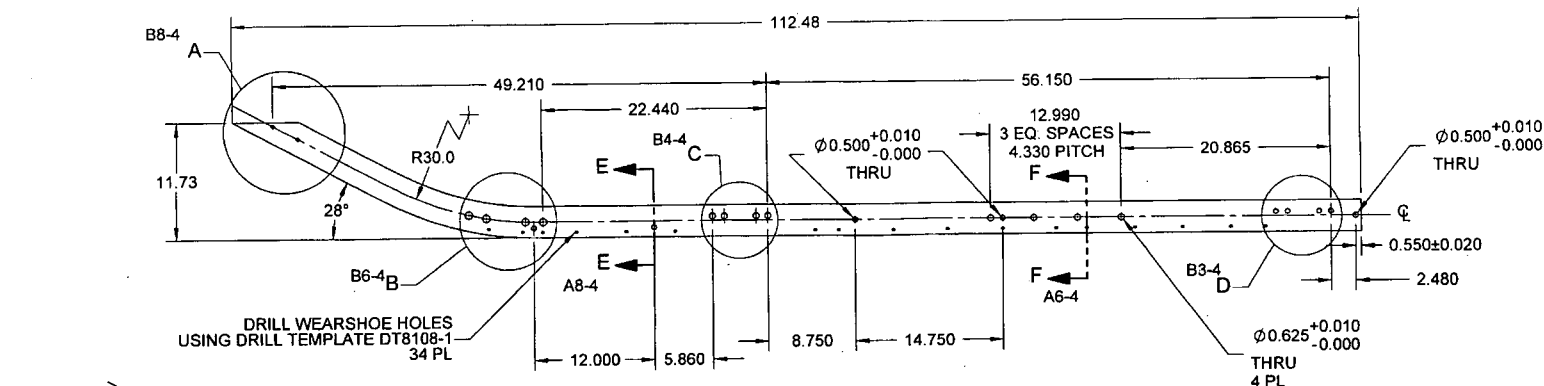
DESIGN	pel	DART AEROSPACE USA, INC.	
DRAWN	pel	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO. D2750	REV. F
MFG. APPR.	SA	SHEET 3 OF 11	
APPROVED	SA	TITLE	SCALE
DE APPR.	SA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O 51803

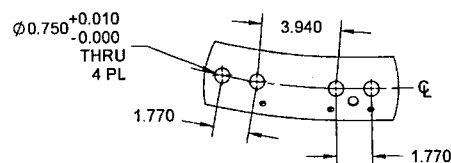
D2750-1 LH SKIDTUBE

RELEASED

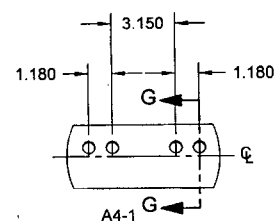
DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



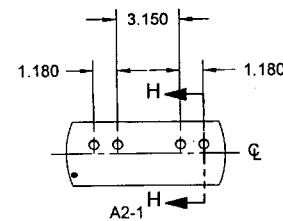
DETAIL A
SCALE 2X



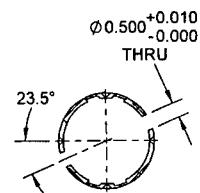
DETAIL B
SCALE 2X



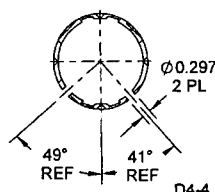
DETAIL C
SCALE 2X



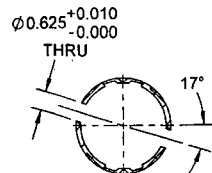
DETAIL D
SCALE 2X



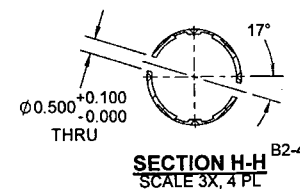
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL

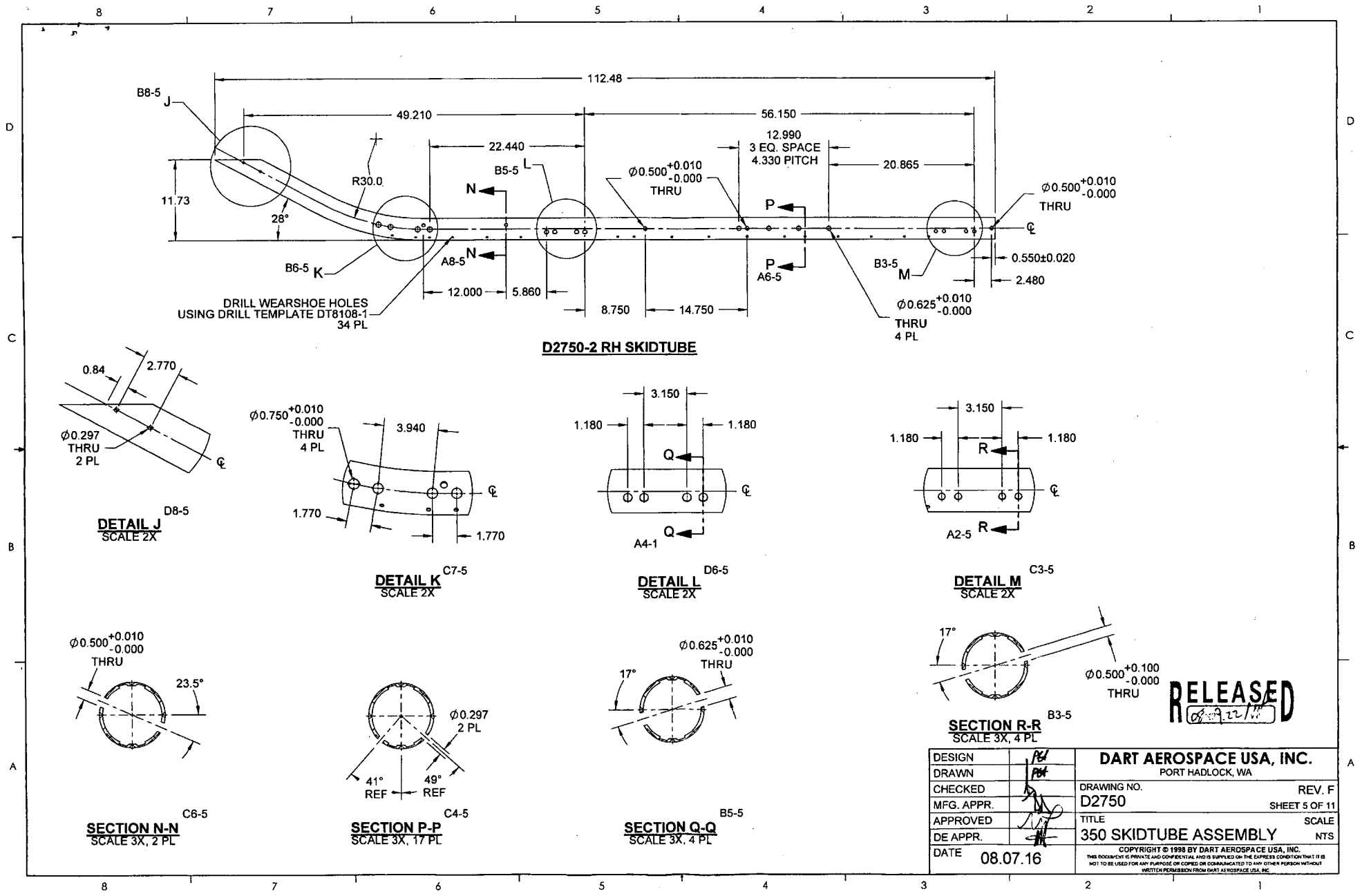


SECTION G-G
SCALE 3X, 4 PL



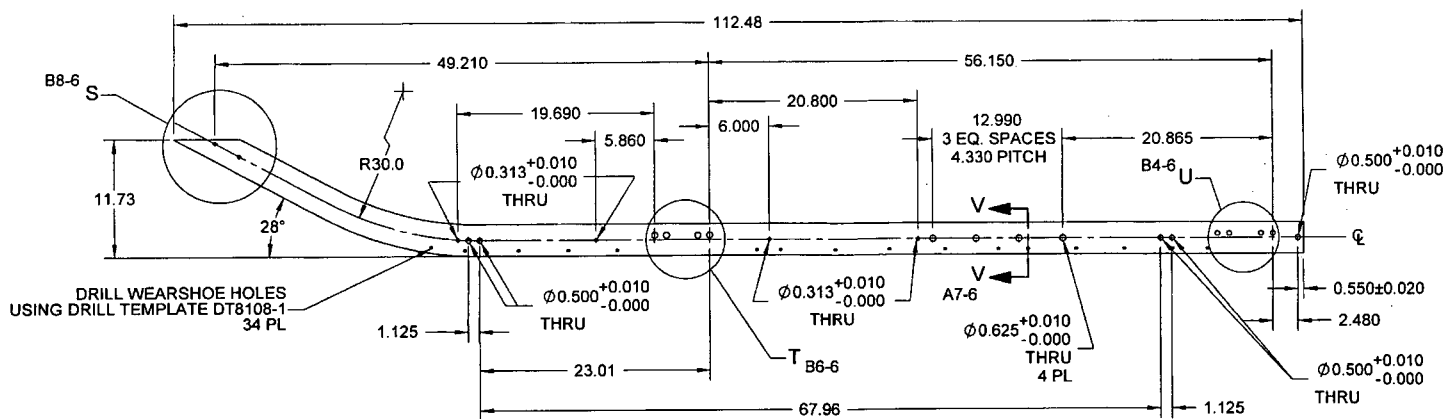
SECTION H-H
SCALE 3X, 4 PL

w/o 51803

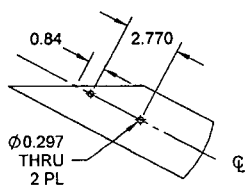


DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

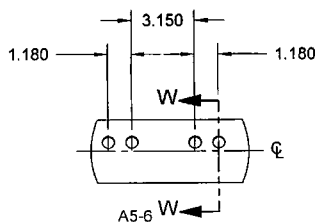
40 51803



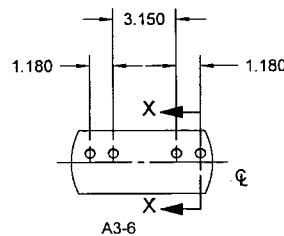
D2750-3 LH SKIDTUBE



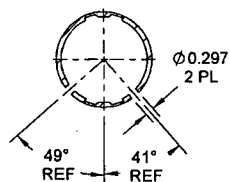
DETAIL S
SCALE 2X



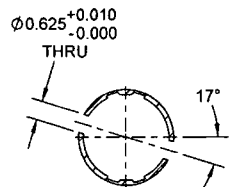
DETAIL T
SCALE 2X



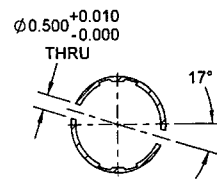
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

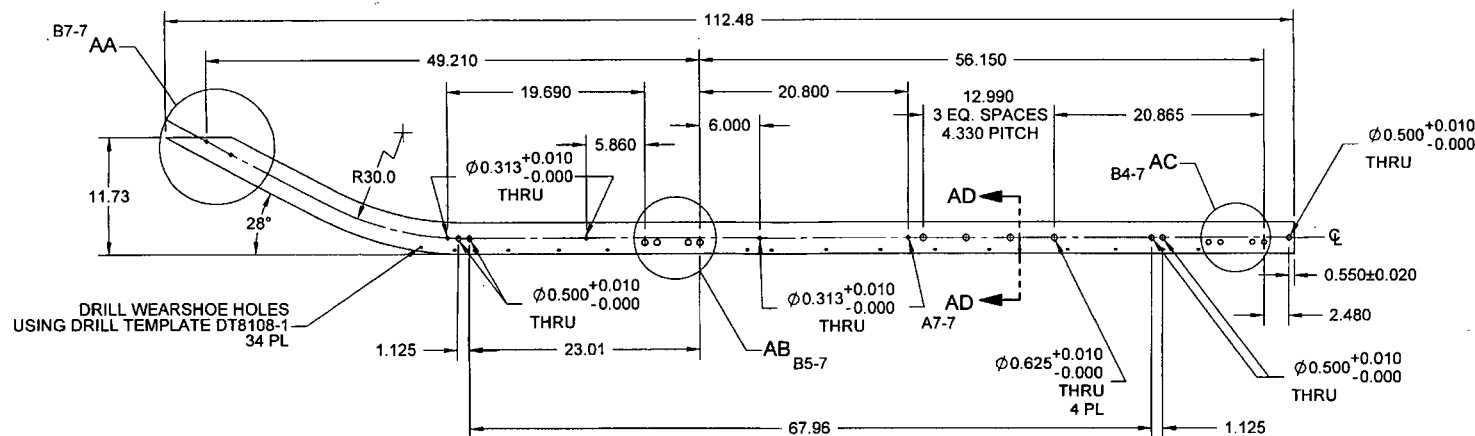


SECTION X-X
SCALE 3X, 4 PL

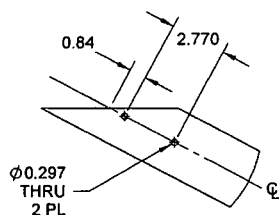
RELEASED

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 6 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	SCALE
DE APPR.			NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

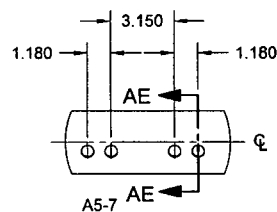
4/0 51803



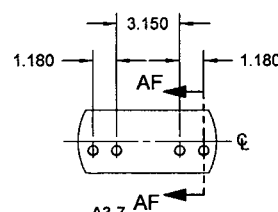
D2750-4 RH SKIDTUBE



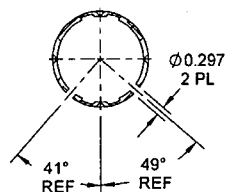
DETAIL AA
SCALE 2X



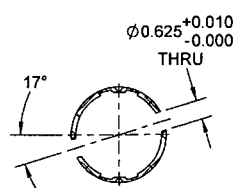
DETAIL AB
SCALE 2X



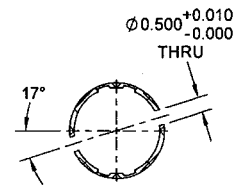
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

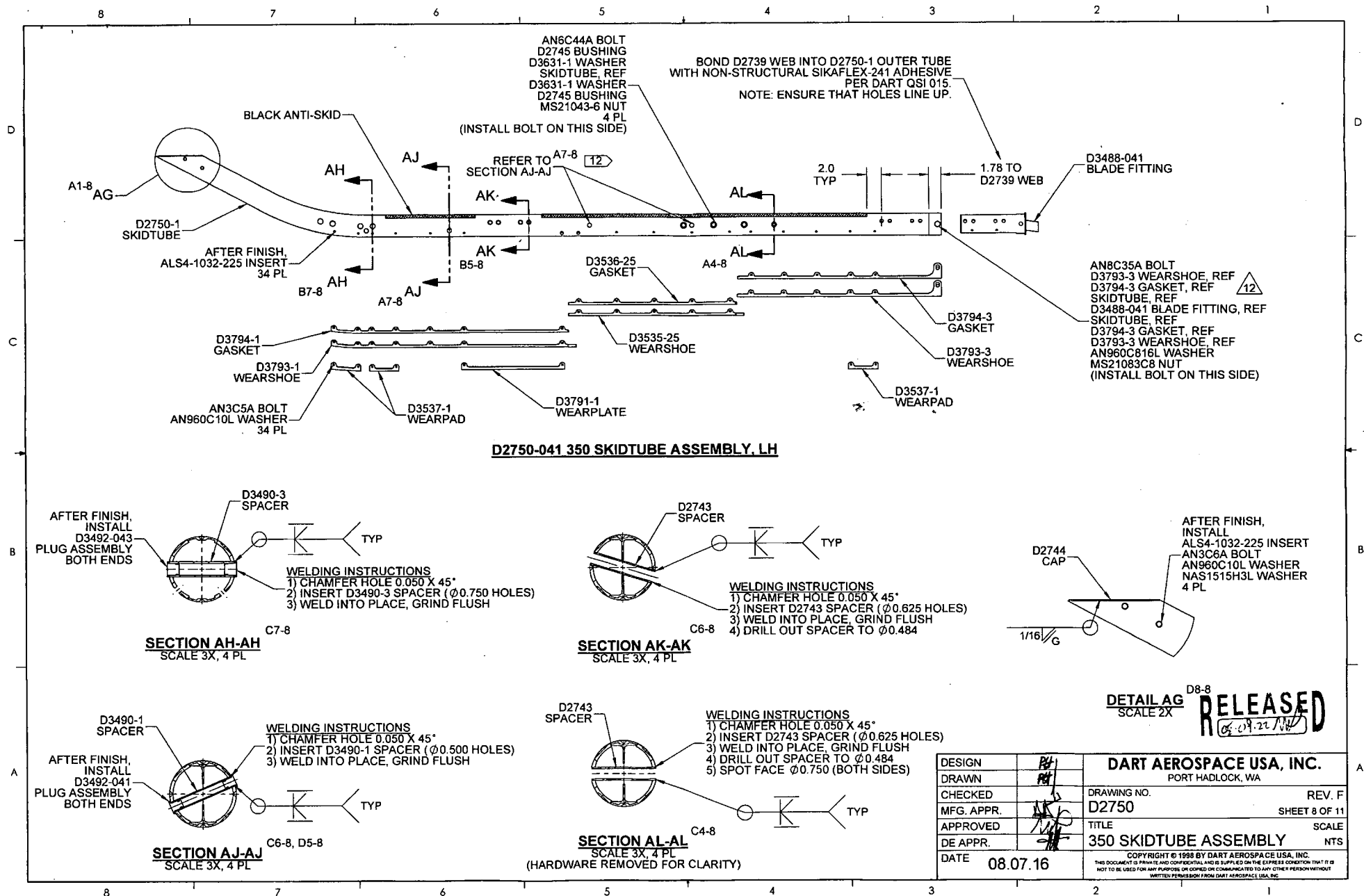


SECTION AF-AF
SCALE 3X, 4 PL

RELEASED

DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 7 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

w/o 51803



D2750-041 350 SKIDTUBE ASSEMBLY, LH

SECTION AH-AH
SCALE 3X, 4 PL

SECTION AK-AK
SCALE 3X, 4 PL

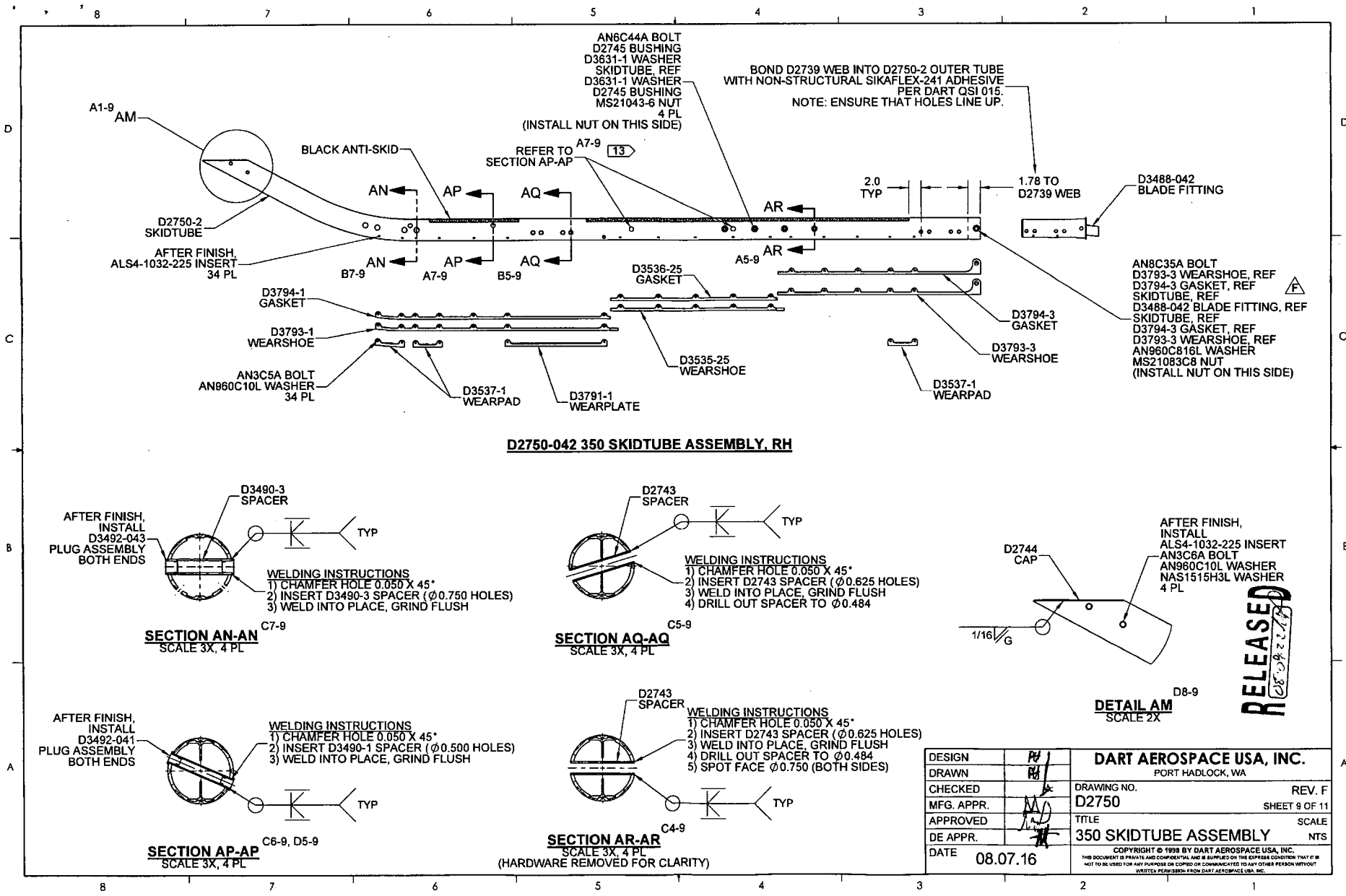
SECTION AJ-AJ
SCALE 3X, 4 PL

SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

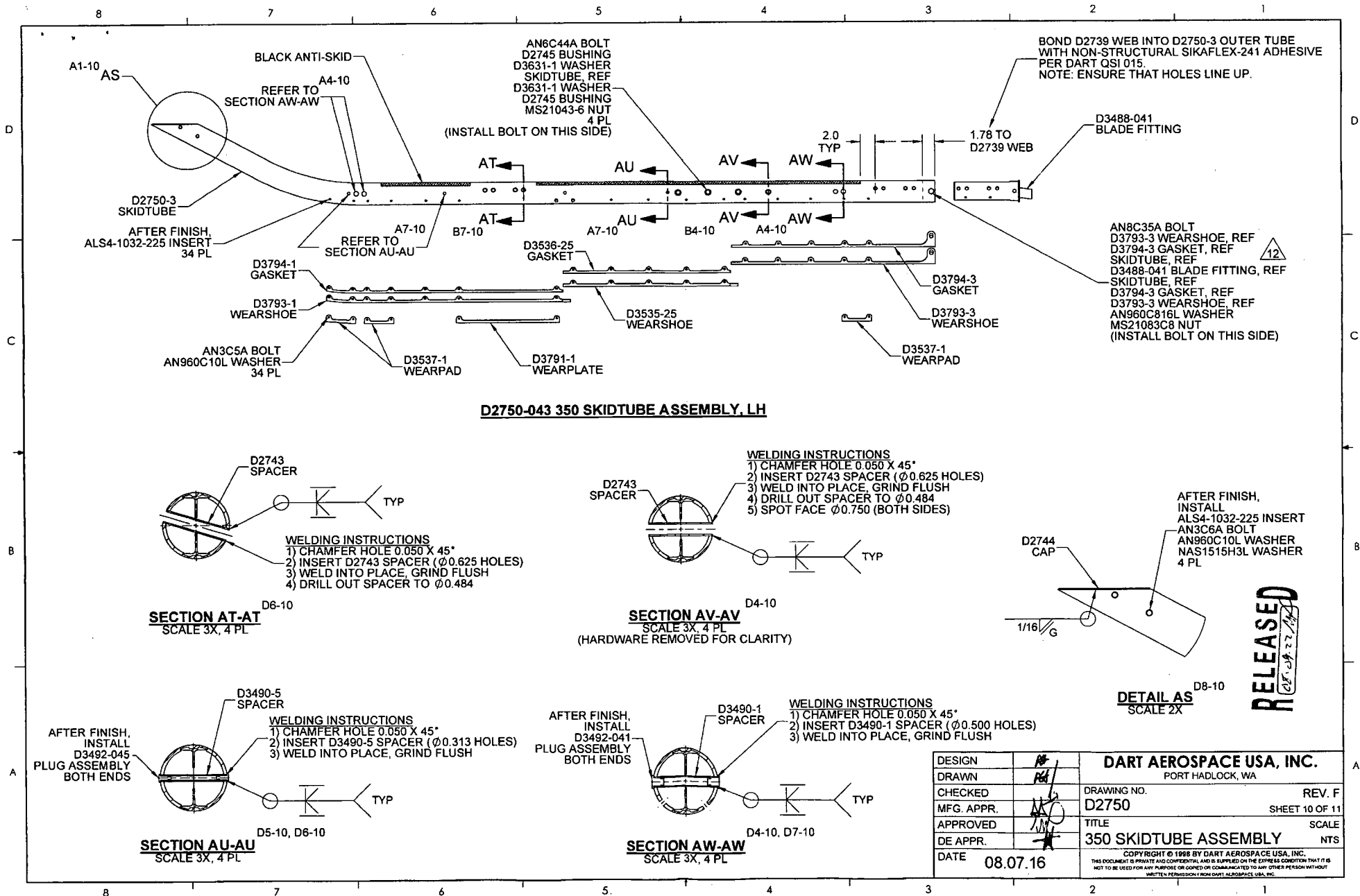
DETAIL A8
SCALE 2X
RELEASED

DESIGN	REV. F	DART AEROSPACE USA, INC.	
DRAWN	REV. F	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W2 51803



4/0 51803



DESIGN	AS	DART AEROSPACE USA, INC.	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	D2750	SHEET 10 OF 11
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

D2750-044 350 SKIDTUBE ASSEMBLY, RH

SECTION BB-BB
SCALE 3X, 4 PL

SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

SECTION BC-BC
SCALE 3X, 4 PL

SECTION BE-BE
SCALE 3X, 4 PL

DETAIL BA
SCALE 2X

WELDING INSTRUCTIONS

1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484

1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

DART AEROSPACE USA, INC.
PORT HADLOCK, WA


DRAWING NO. D2750
TITLE 350 SKIDTUBE ASSEMBLY
REV. F
SHEET 11 OF 11
SCALE NTS

DATE 08.07.16

COPYRIGHT © 1988 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

AFTER FINISH,
INSTALL
ALS4-1032-225 IN SERT
AN3C6A BOLT
AN960C10L WASHER
NAS1515H3L WASHER
4 PL

DETAIL BA
SCALE 2X

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

NO. 209

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: A. R. Avel
Job number: 51803
Part number: A350-636-011
Description: 350 SK tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier: [Signature] Date of Test Coupon 09/09/08
Welder: [Signature] Date of Test Coupon 09.09.08

The above named individual is qualified in accordance with AWS D17.1.2001 to weld